

Date: Thursday, 26/10/2006 7:49:55 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 29181		
Estimate Number	: 10733		
P.O. Number	: <i>N/A</i>	Part Number	: D30461
This Issue	: 26/10/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3046 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 29176	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 26/10/2006 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est A 01.08.27 New Issue SM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S12GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.1260 sf(s)/Unit Total: 0.5040 sf(s)

1010/1025/A21/6aA SHEET

Batch: *10102247**mm 06 10 26*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3046

Dwg Rev: *A*Prog Rev: *A**mm 06 10 26**(4)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*mm 06 10 26**(4)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*Job 10-26 (4)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Tumble &amp; deburr

Bend as per dwg D3046

*SB 06/10/26 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 26/10/2006 7:49:55 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 29181

Part Number: D30461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206.10.26 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

YL 06/10/26 x4

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/10/26

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST120

GA

SB 06/10/26

LB 06/10/26

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(H) 06/10/26

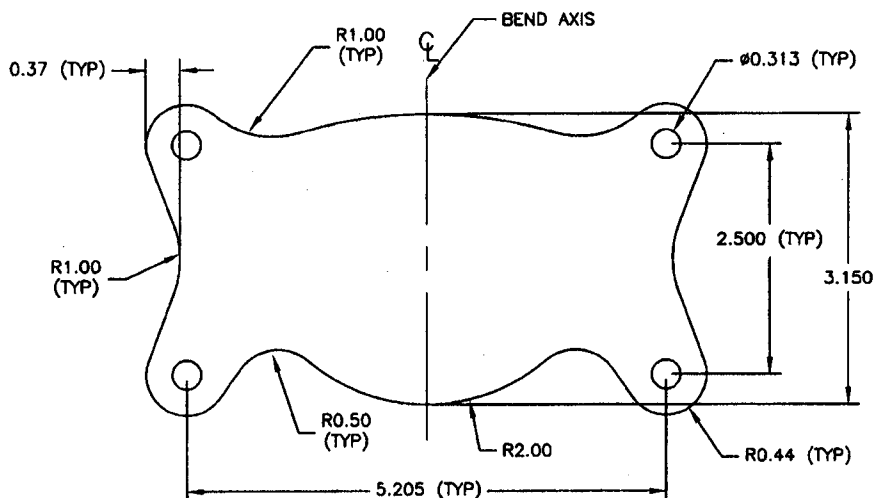
Job Completion



C 206/10/26

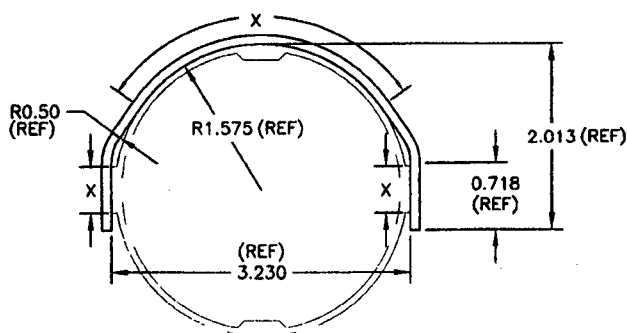


DESIGN <i>[Signature]</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN  
SYMMETRICAL ABOUT CENTRE-LINES (CL)

REFERENCE ONLY



D3046-1  
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

#### GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

RELEASED  
01.08.27

UNDER REVIEW  
06.06.27

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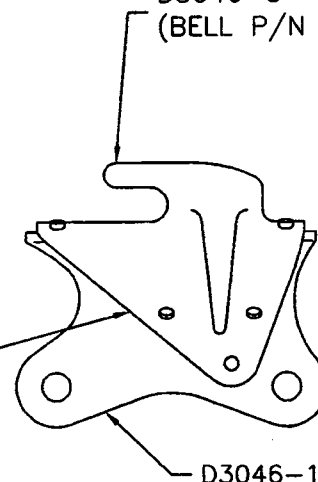
**DART**



DESIGN		DRAWN BY		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. A
DATE	01.08.23	DRAWING NO.	D3046	SHEET 1 OF 2
		TITLE	LUG BRACKET	SCALE
A		01.08.23	NEW ISSUE	1:2

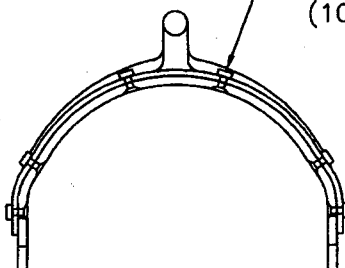
**REFERENCE ONLY**

D3046-3  
(BELL P/N 206-052-106-1)



CENTER D3046-3  
ON D3046-1

TRANSFER DRILL  $\varnothing 0.156$  HOLES  
FROM D3046-3 TO D3046-1.  
C'SINK  $\varnothing 0.286 \times 100^\circ$   
D3046-1 INSIDE BORE.  
ASSEMBLE USING MS20426AD5-7  
RIVETS.  
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

**NOTES:**

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

**UNDER REVIEW**

06.06.02   
CHANGING TO WELDED  
DESIGN

**RELEASED**  
01.08.23

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 29181
<b>Description:</b> Lug Bracket	<b>Part Number:</b> D3046-1
<b>Inspection Dwg:</b> 3046 <b>Rev:</b> A	Page 1 of 1


## FIRST ARTICLE INSPECTION CHECKLIST

**X First Article**

**x Prototype**

[illegible]

Measured by:	<i>M. M.</i>
Date:	<i>26 10 26</i>

Audited by:	
Date:	06/02/20

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	